

**Work Order ID 59805**

June 11, 2010



Page 1

Item ID:

Revision ID:

Item Name:

Draw Nbr:

Start Date: 6/11/10 9:20: Start Qty: 1.00



Revision Nbr:

Required Date: 6/01/10 Reqd Qty: 1.00



Reference: ECN10-574

Cust Item ID:

Customer ID:


Description: DSI9520  
D212-664-201/-207

Sales Order:

Approvals: Process Plan:  Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**Hours**

Sequence ID	Work Center ID	Operation Description	Set Up	Run	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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QC21 10/06/17 

U 10-06-11

# List Lots

Wednesday, May 19, 2010 9:54:53 AM

Page 1 of 1

Criteria : Item ID: d212-664-201 All Locations All Warehouses All Quantity

Item ID Item Name	Warehouse ID Location ID	Lot Number	Last Trans Date	Lot Qty	Shelf Life Dt	Lot Code	Type Code	Comments
D212-664-201 Crosstube Aft	HONG KONG	39659	4/15/2010	1.0000		QC21	CHG003	Paperwork not updated in HK
	FG							
	Main Warehouse	57024	4/15/2010	1.0000		QC21	CHG003	shipped 2/4/05 ✓ u
	FG103							
	OFFSHORE	38844	4/15/2010	1.0000		QC21	CHG003	
	FG							
Total:				3.0000				

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# List Lots

Wednesday, May 19, 2010 9:55:19 AM

Page 1 of 1

Criteria : Item ID: d212-664-207 All Locations All Warehouses All Quantity

Item ID Item Name	Warehouse ID Location ID	Lot Number	Last Trans Date	Lot Qty	Shelf Life Dt Lot Code	Type Code	Comments
D212-664-207 Crosstube Low Standard Aft	Main Warehouse FG053	55919	4/9/2010	1.0000	QC21	CHG001	
	Main Warehouse FG053	55920	4/9/2010	1.0000	QC21	CHG001	

Total: 2.0000

10.5.25  
8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D212-664 REF. F OR EARLIER AND  
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D212-664 REV. 5 OR EARLIER

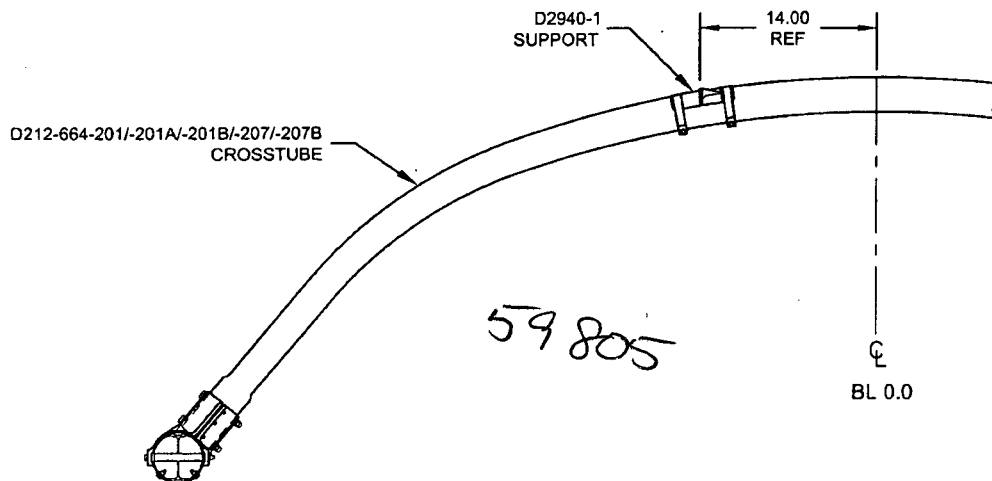
REF. TCCA STC: SH01-9

REF. FAA STC: SR01298NY

REF. EASA STC: EASA.IM.R.S.01304

FOR D212-664-201/-201A AT CHG 003 AND EARLIER AND D212-664-201B/-207/-207B AT CHG 001, THE D2940-1 MAY REQUIRE REWORK WHEN INSTALLING THE AFOREMENTIONED CROSSTUBES ON BELL 204B, UH-1A/B/E/F/L/P, TH-1F/L, AND HH-1K MODEL AIRCRAFT AS OUTLINED BELOW.

- 1) PERFORM ITEM 3.5 OF IIN-D212-664. ENSURE THAT THE REWORK OUTLINED IN TB-204-80-16 (REF. BHT-204-SI-31) IS PERFORMED TO THE HIGHEST END OF THE TOLERANCE ON THE RADIUS OF THE SHIM, R1.775.
- 2) REMOVE THE D2940-1 SUPPORTS FROM THE DART D212-664-201/-201A/-201B/-207/-207B CROSSTUBES PER SECTION 32.3 OF ICA-D212-664.
- 3) REWORK THE D2940-1 SUPPORTS AS SHOWN IN FIGURE 2 OF THIS SERVICE INSTRUCTION.
- 4) TOUCH UP AFFECTED AREAS WITH TWO COATS OF MIL-P-85582 OR MIL-P-23377 PRIMER AND 2-3 COATS OF MIL-C-85285 POLYURETHANE PAINT TO MATCH ORIGINAL FINISH.
- 5) RE-INSTALL THE REWORKED D2940-1 SUPPORTS ON THE CROSSTUBE PER SECTION 32.4 OF ICA-D212-664.
- 6) COMPLETE INSTALLATION OF D212-664-201/-201A/-201B/-207/-207B CROSSTUBES PER SECTION 3.0 OF IIN-D212-664.



**FIGURE 1 - D212-664-201/-201A/-201B/-207/-207B CROSSTUBE OVERVIEW**  
(204B, UH-1A/B/E/F/L/P, TH-1F/L, AND HH-1K MODEL AIRCRAFT ONLY)

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

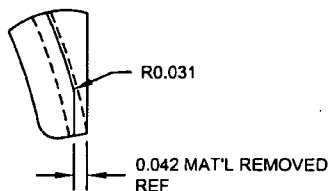
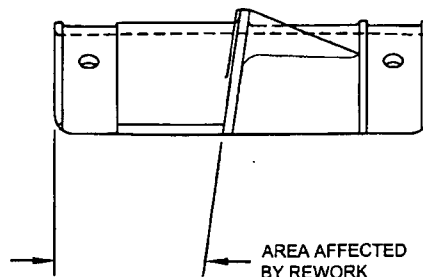
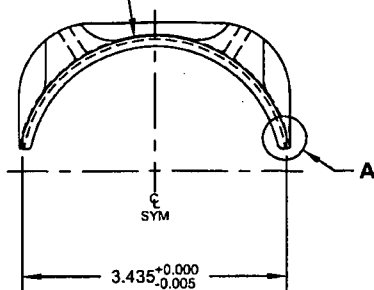
BY: *[Signature]*  
D. SHEPHERD (DE # 02)

DATE: 10.05.06  
CERT. NO.: SH01-9  
ISSUE NO.: 3

A	NEW ISSUE	MB	10.05.06
REV.	DESCRIPTION	BY	DATE
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DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9521	SHEET 1 OF 2
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DE APPR.	<i>[Signature]</i>	CROSSTUBE INSTALL ON 204B	NTS
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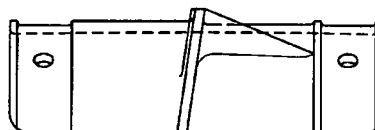
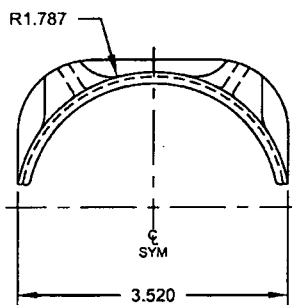
**IS:**

GRIND/BUFF  
TO R1.775



**DETAIL A**  
SCALE 4X

**WAS:**



59805

**FIGURE 2 - D2940-1 SUPPORT REWORK**  
(204B, UH-1A/B/E/F/L/P, TH-1F/L, AND HH-1K MODEL AIRCRAFT ONLY)

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

**APPROVED**

BY: *[Signature]*  
D. SHEPHERD (DE # 02)

DATE: 10.05.06  
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